

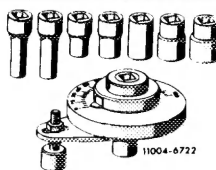
Tightening torques		Nm
Necked-down screw for camshaft gear		80
Connecting rod nuts	initial torque	40–50
	angle of rotation torque	90–100°
Necked-down screws for flywheel or driven plate	initial torque	30–40
	angle of rotation torque	90–100°
Crankshaft bearing bolts		90

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#### Special tool

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Angle of rotation tool



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#### Self-made tool

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Gauge for cutting-off rear radial sealing ring

refer to Fig. item 4

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#### Note

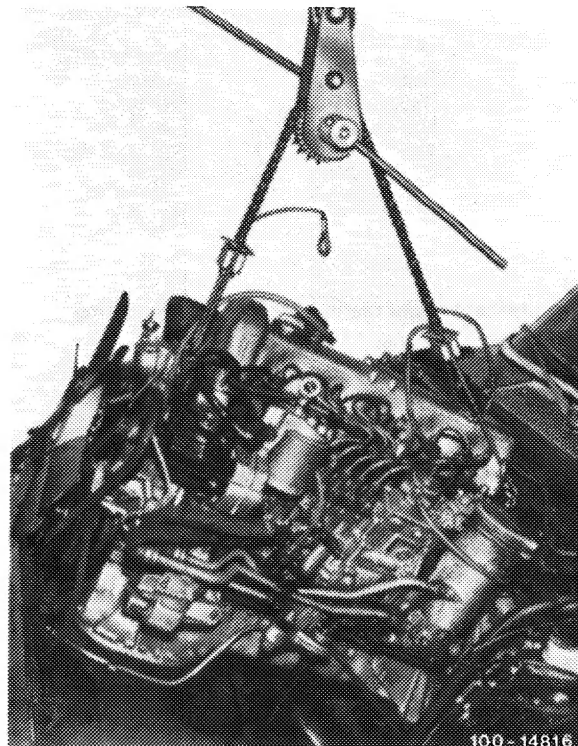
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The radial sealing ring is graphite gray similar to that in other diesel engines.

#### Renewing

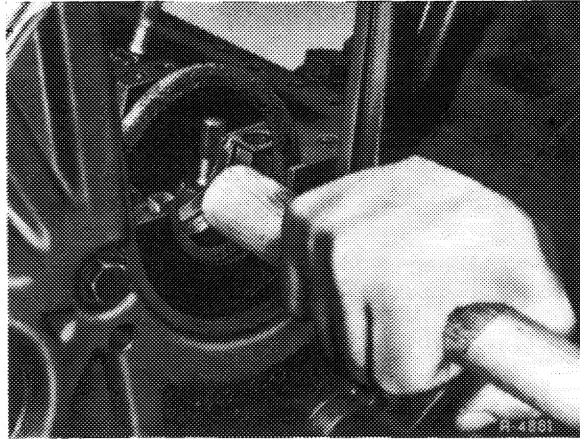
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- 1 Remove engine (01–030).
- 2 Remove crankshaft.

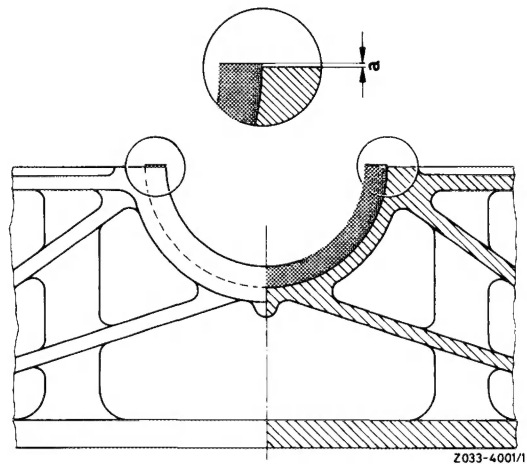


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3 Place radial sealing ring into cylinder crankcase and into oil pan and work in by means of a lubricated hammer handle.

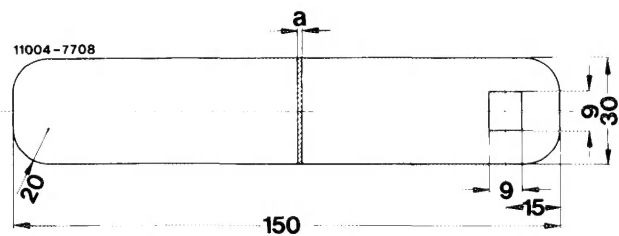


4 To obtain the required overlap, cut off radial sealing ring in cylinder crankcase and oil pan approx. 1.0 mm above parting surface.



Dimension a = 1.0 mm

**Note:** For cutting-off, a self-made template according to drawing can be used.



Dimension a = 1.0 mm

5 Lubricate radial sealing ring prior to installing crankshaft.

6 Install crankshaft.

7 Mount oil pan, rotate crankshaft and check for unobstructed operation.